

Work Order ID 86286

June-26-12 3:05:32 PM

86286

Page 1

Item ID: D3243-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket Assembly

Start Date: 26/06/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/26 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3243	Rev A					8			
110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per dwg								
<u>6061 .063</u>	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									

18 12-6-27

18 12-6-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00 8/26/12

Quality Control

150

NC BRAKE

0.00

150

Brake NC

Memo

0.00

Brake NC

Form as per Dwg D3243

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00 8/26/12

Quality Control

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Chemical Conversion Coat per QSI005 4.1	0.00							
170									
HandFinish	Memo	0.00				8			NG 12.7.10
Hand Finishing									
180		0.00							
180									
Small Fab	Small Fab								
	Memo	0.00							
Small Fab	Install Inserts as per Dwg D3343								
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00							
Quality Control									

826410

82

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Revision ID:

Stop

NS2

Item Name: Bracket Assembly

Start Date: 26/06/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

200

Powdercoat

Powder Coating

Memo

*****Mask Holes*****

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:50
3200 F
2:20

8X 4 M 12/07/11

210

QC3- Inspect Part Finish

0.00

210

QC

Quality Control

Memo

0.00

8x 4 M 12/07/11

220

Identify as per dwg & Stock Location: 227

0.00

220

Packaging

Packaging

Memo

0.00

8 12/7/13

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Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

QC21- Final Inspection - Work Order Release

0.00

230

QC

Memo

0.00

Quality Control

MLJ 12/07/13

MLJ 12/07/13

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Picklist Print

June-26-12 3:05:36 PM

Page 1
1

Work Order ID: 86286

86286

Parent Item: D3243-041

D3243-041

Parent Item Name: Bracket Assembly

Start Date: 26/06/2012

Required Date: 10/07/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 05-11-29 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063

Purchased

No

110

sf

530.5868

0.5499

4.630737

51

M6061T6S 063

**

B12-6-27

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT021

530.5868320

113608

0

116308

5.01556842

117285

67.544

119331

44.2

119802

5.94

120218

17.31

120866

64.8126316

121805

325.764632

FE-032-EF

Purchased

No

180

Each

250.0000

4

32

FF-032-FF

**

Inserts

Location

Loc Qty

Loc Code

ST285

250

110836

14

117168

136

117226

100

⑧

121805

12/07/10

32

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

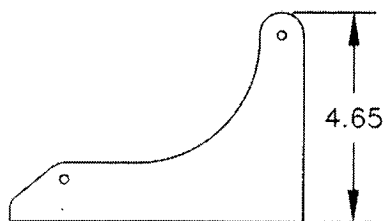
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D3243	REV. A SHEET 1 OF 1
DATE 04.01.09		TITLE BRACKET	SCALE 1:2
A	04.01.09	NEW ISSUE	



R0.188 (TYP)



D3243-1 BEND DETAIL/
D3243-041 ASSEMBLY
SCALE 1:4

INSTALL
FE-032-EF INSERTS
(4 PLACES)

2.75^{+0.030}
0.000

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *86286-MC*
12/06/26

11.920
11.420

Ø0.201
(TYP 4
PLACES)

Ø0.290
(TYP 4
PLACES)

1.375

5.273

3.714

0.500

0.000

0.750
0.500
0.000

GRAIN
DIRECTION

8.581
8.206
7.706

4.214
R0.25 (TYP)
3.339
R0.38 (TYP)
5.494

R2.75
(TYP)

D3243-1
FLAT PATTERN

R0.50
(TYP)

6.560
5.810
5.360

RELEASED
04.02.03

**D3243-041 BRACKET ASSEMBLY
(D3243-1 BRACKET)**

- 1) MATERIAL: 6061-T6, 0.063 THICK
(QQ-A-250/11, REF DART SPEC
M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO
0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

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